

Work Order ID 71672

Thursday, July 07, 2011 12:10:20 PM



Page 1

Item ID: D3245-1

Accept



Setup Start



Revision ID:

Item Name: Panel

Stop



Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: C2

Date: 11/07/07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3245

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3245

****prog.D3245-1/-2****

☐Dwg

Rev: B

☐Prog Rev: B

☐2-Deburr if necessary

304.032

B11-8-10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Subtotal

78

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71672

Thursday, July 07, 2011 12:10:20 PM



Page 2

Item ID: D3245-1

Accept



Setup Start



Revision ID:

Item Name: Panel

Stop



Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Deburr if necessary ☐ C'sink as per Dwg D3245 ☐ Form D3245-1 as per Dwg D3245 Identify as D3245-1

SB 11/6/27 *EP 11/6/27* *(S)*

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/16/27 *(S)*

150



Identify as per dwg & Stock Location: *GA*

0.00

Packaging

Memo

0.00

Packaging

EP 11/6/28 *(S)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71672

Thursday, July 07, 2011 12:10:20 PM



Page 3

Item ID: D3245-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/3

ME 11-09-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:10:18 PM

Page 1

Work Order ID: 71672

Parent Item: D3245-1

Parent Item Name: Panel



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A 04.07.07 New issue KJ/JLM
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 		Purchased	No			100	sf	43.3600	0.804	6.770526			
304/316 .032 Sheet										B 11-8-10			

Location

Loc Qty

Loc Code

020 5.8
109057 5.8
MAT020 37.56
117379 37.56

118400

118400

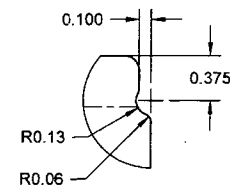
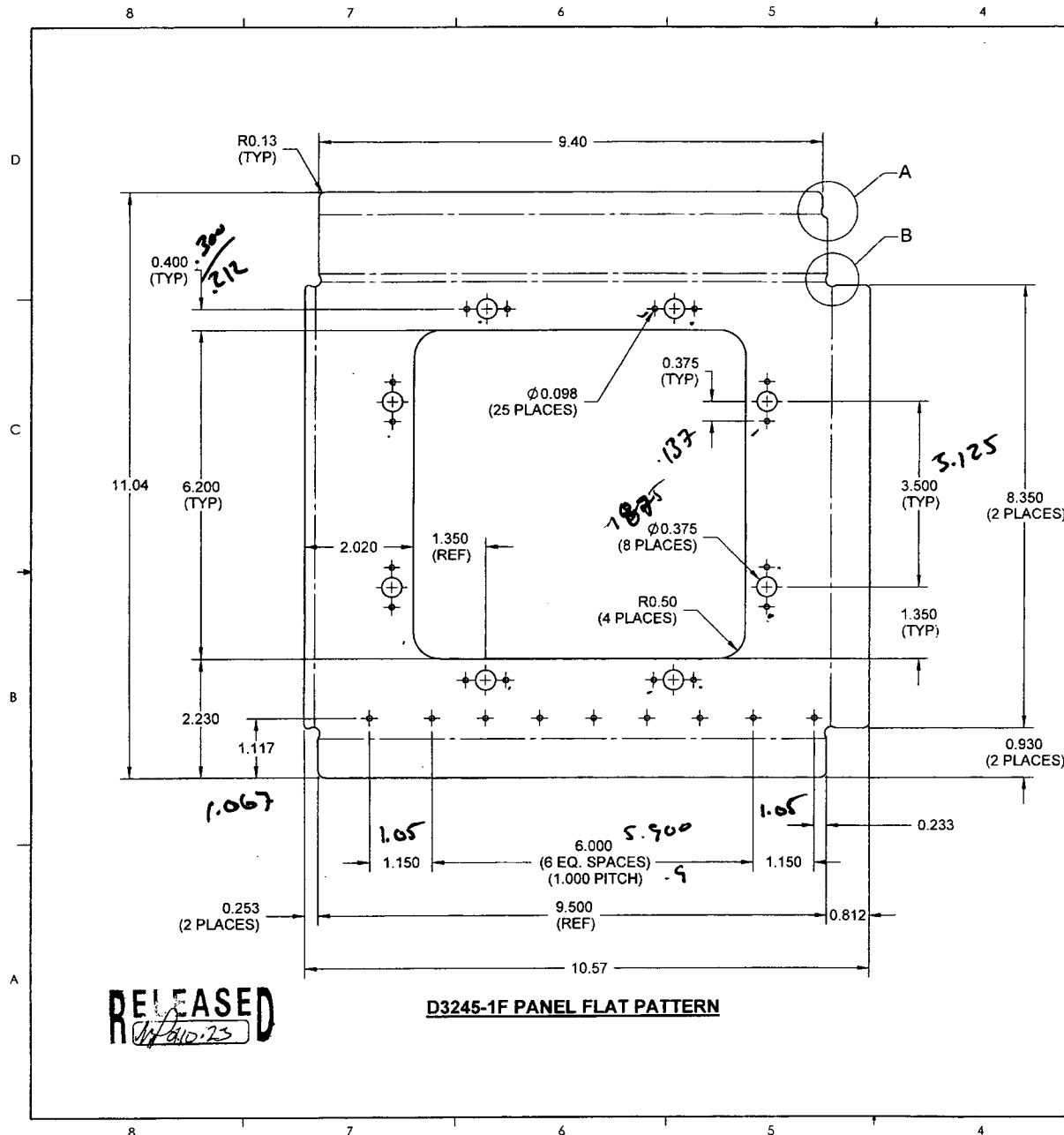
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

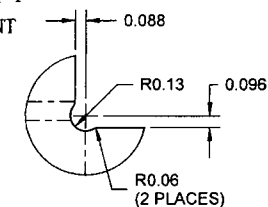
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A: RELIEF
SCALE 1:1

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WORK ORDER
NO 71672



DETAIL B: RELIEF
(TYP. 4 PLACES)
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
(0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	<i>71672</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. D3245	REV. B
MFG. APPR.	<i>PH</i>		SHEET 4 OF 7
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	ACCESS PANEL ASSEMBLY	1:2
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
11/21/02

D3245-1F PANEL FLAT PATTERN

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

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CZ1107/67

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

RELEASED
07-10-23

NOTES:

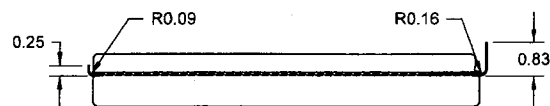
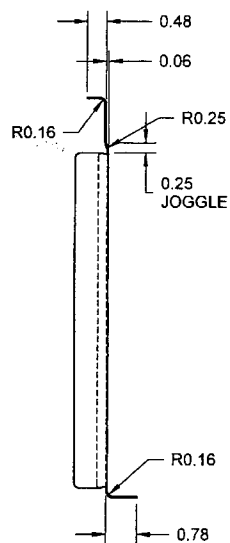
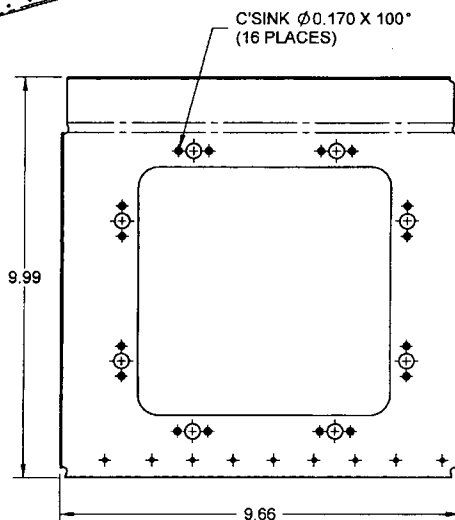
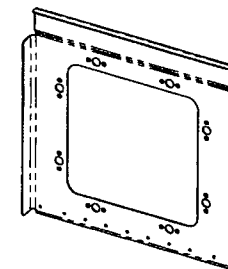
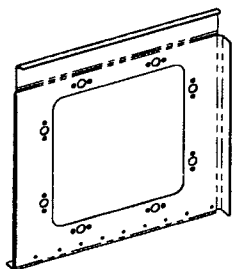
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

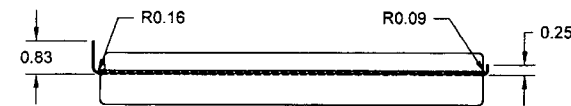
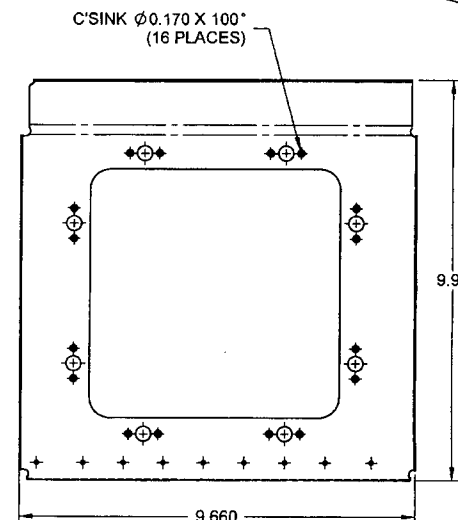
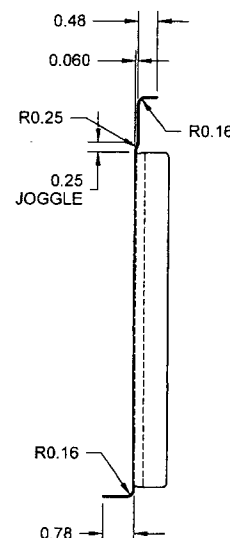
D3245-042 ACCESS PANEL ASSEMBLY

B	REMOVE Ø0.204 HOLES FROM D3245-11-1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.02		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3245	REV. B
TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2.5
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D3245-1 PANEL BEND DETAIL, LH



D3245-2 PANEL BEND DETAIL, RH

RELEASED
10-10-23

- NOTES:
 1) MATERIAL: MAKE FROM D3245-1F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.70 lbs

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 RETURN TO
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 WITHOUT NOTICE
 WORK ORDER
 NO. 71672

DESIGN	716	DART AEROSPACE LTD	
DRAWN	8	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	SS	D3245	SHEET 2 OF 7
APPROVED	140	TITLE	SCALE
DE APPR.	716	ACCESS PANEL ASSEMBLY	1:3
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